

Date: Monday, 11/05/2009 3:45:47 PM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D204-618-011
 Job Number : 47895
 Estimate Number : 10804
 P.O. Number :
 This Issue : 11/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11/05/2009 Type : LARGE FAB ASSY
 Previous Run : 00015
 Written By :
 Checked & Approved By : JUD 09.05.11
 Comment :
 Part Number : D204618011
 Drawing Number : R09-047
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 18/05/2009 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D204618011 Heli-Access-Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Heli-Access-Step
 Original B34979 @ CHG002

2.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 New labels and decals are required with the new batch #, and still remain at CHG002

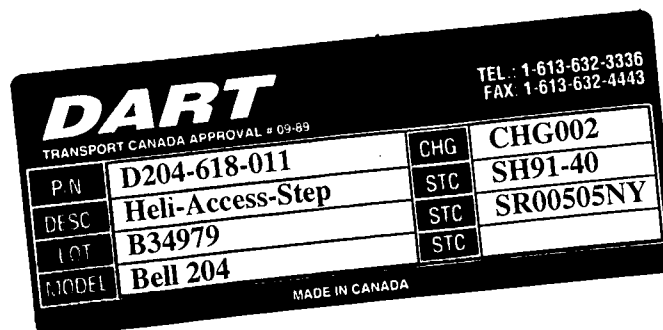
Re-package and return to stock
 Location: _____

4.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:37:43 AM
 User: Kim Johnston

Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BELL 204 STEP
 Job Number : 34979
 Estimate Number : 12416
 P.O. Number :
 This Issue : 10/3/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : LARGE FAB ASSY
 Previous Run : 33164
 Written By :
 Checked & Approved By : 07.10.03
 Comment : Est Rev:D Add GGH Number 06-05-18 JLM
 EST REV E fixed eyebolt issue 07.06.26 EC

Part Number : D204618011
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 10/30/2007 Qty: 4 Um: Each

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD204-618-01 CHG002

08/04/08 07.10.04

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D2017121 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: 033204 ✓

50

4.0 D2017123 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch: 033205 ✓ ✓

50

5.0 D2017125 Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: 034982 ✓

8/4/11

50

(4x)

Drawing Name: BELL 204 STEP

Part Number: D204618011



6.0	D2017127	Strut
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7.0	D2017129	Strut
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8.0	D2017131	Strut
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9.0	D2349	Mounting Plate(204 Step)
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10.0 D2460 Step Ass'y



11.0	AN45A	Bolt
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12.0	AN47A	~	Bolt
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2

y, 10/3/2007 8:37:43 AM

viston

Process Sheet

CU-DAR001 Part Helicopters Services

Drawing Name: BELL 204 STEP

per: 34979

Part Number: D204618011

at:



J. #: Machine Or Operation: Description :

13.0 AN410A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch:

M101291 (1X)

M105442 (7X)

SQ

14.0 AN414A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M13183 (1X)

M105653 (3X)

SQ

15.0 AN511A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M105810 ✓

SQ

16.0 AN44 7A EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

EYEBOLT

Batch:

M106763 2X

M107678 2X / 8/4/8

SQ

*****ENSURE THIS IS AN44-7A EYEBOLT NOT AN4-47A BOLT*****

17.0 AN960JD416 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Batch:

M106780 ✓

SQ

18.0 AN960JD516 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Batch:

M106654 ✓

SQ

19.0 MS21042L4 Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Batch:

M106825 ✓

8/4/11

SQ

(1X)

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: BELL 204 STEP

ber: 34979

Part Number: D204618011

er:



q. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 20000 Each(s)/Unit Total: 8.0000 Each(s)
Nut

M106271 ✓

SP

21.0

MS20600AD4W6

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)
Rivet

Batch: M1063481 ✓

8/4/11

SP

(4X)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/08 (4X)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-618-011

Location:

PPP Rev: G

8/4/11 (4X)

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion

DATE



mf 08-04-09

W

DART			
TRANSPORT CANADA APPROVAL # 09-69			
P N	D204-618-011	CHG	CHG002
DESC	Heli-Access-Step	STC	SH91-40
LOT	B34979	STC	SR09505NY
MODEL	Bell 204	STC	
MADE IN CANADA			

TEL: 1-613-632-3336
FAX: 1-613-632-4443